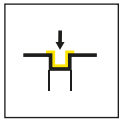


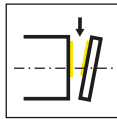


全新硬质合金材质IG6
在加工普通钢和不锈钢时有更多表现

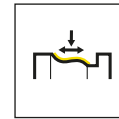
NEW CARBIDE GRADE IG6
MORE PERFORMANCE IN THE MACHINING
OF ORDINARY AND STAINLESS STEELS



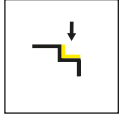
切槽
Grooving



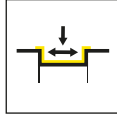
切断
Parting off



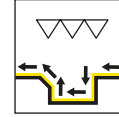
仿形车削
Copy turning



局部切削
Partial cut



横向车削
Side turning



精加工车削
Fine turning

除非另有说明，所有尺寸的单位是毫米。

All dimensions are in mm, unless otherwise stated.

交货期:

- ▲ 库存产品
- △ 4 周

用于材料组:

- 推荐
- 选择推荐
- 不合适

Delivery times:

- ▲ on stock
- △ 4 weeks

Use for material groups:

- recommended
- alternative recommendation
- not suitable

HORN的连接代码--需要它做什么？

连接代码确保你总是能找到合适的刀具，并显示在刀柄和刀片上。如果代码相符，刀片可以在相应的刀柄上使用。

这也适用于我们的模块化刀柄系统，连接代码表示导杆和刀夹之间的接口。

The HORN connection interface code - what is it needed for?

The connection interface code ensures that you will always find the appropriate tools and is shown on toolholders and inserts.

If the codes match, the insert can be used in the corresponding toolholder.

This also applies to our modular holder system, where the connection code indicates the interface between the holder and the cassette.

HORN连接代码和可能的组合：

HORN connection interface codes and possible combinations:

HIS = 刀片座 / Insert seat

HWS = 工件端接口 / Interface workpiece side

HMS = 机床端接口 / Interface machine side

HIS	↔	HWS
HMS	↔	HWS

刀片型号举例

Example insert

产品名称 Part number	w	r	HIS	IG66
S229.0030.K6	6	3	229050	▲

刀夹举例

Example cassette

产品名称 Part number	t _{max}	f ₂	f ₃	D _{max}	l _K	HWS	HMS
RNK220.3215.4.05.IK	25	13,9	f ₂ +w/2	180	38	229050 • 229051	220001

基础刀杆举例

Example basic holder

产品名称 Part number	l ₁	d	f ₁	l	l ₂	f	h ₁	HWS
HSKT63.R220.110.K1.IK	81	63	0,6	l ₁ +l _K	91	f ₁ +f ₃	12,5	220001

不同之处： 更多可能

THE DIFFERENCE: MORE POSSIBILITIES

- **耐热性的材质带来增加的生产率**
Increased productivity thanks to heat-resistant grade
- **不锈钢材料的高效加工**
Efficient machining of stainless materials
- **内部的涂层工艺带来快速的响应时间**
Fast delivery times due to in-house coating

槽型和进给率

Geometries and Feed Rates



槽型 Geometry	材料 Material	进给率 f [mm/U] Feed rate f [mm/rev]	加工 Machining						
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,05-0,15</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,15-0,20 ↔ 0,03-0,40</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,10-0,45 ↔ 0,15-0,60</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,03-0,15 ↔ 0,05-0,20</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,10-0,40</p>	
P	M	K							
N	S	H							

槽型和进给率

Geometries and Feed Rates



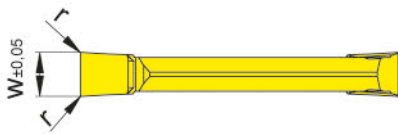
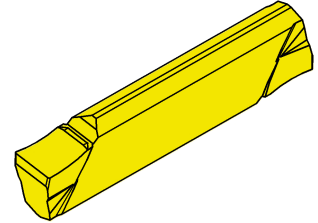
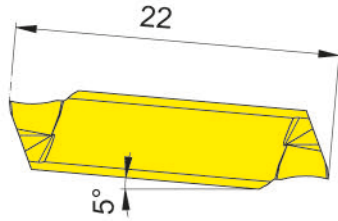
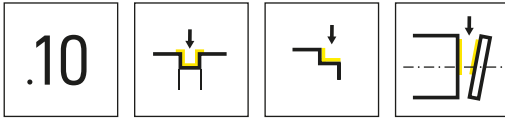
槽型 Geometry	材料 Material	进给率 f [mm/U] Feed rate f [mm/rev]	加工 Machining						
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,20-0,30</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,05-0,25 ↔ 0,05-0,40</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,05-0,25 ↔ 0,05-0,40</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,10-0,22 ↔ 0,05-0,22</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,10-0,22 ↔ 0,05-0,20</p>	
P	M	K							
N	S	H							

槽型和进给率

Geometries and Feed Rates



槽型 Geometry	材料 Material	进给率 f [mm/U] Feed rate f [mm/rev]	加工 Machining						
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,07-0,25</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,02-0,10 ↔ 0,0015-0,07</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,05-0,25 ↔ 0,05-0,25</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,05-0,30 ↔ 0,10-0,30</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ 0,15-0,25 ↔ 0,10-0,25</p>	
P	M	K							
N	S	H							



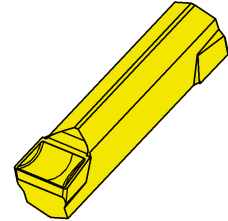
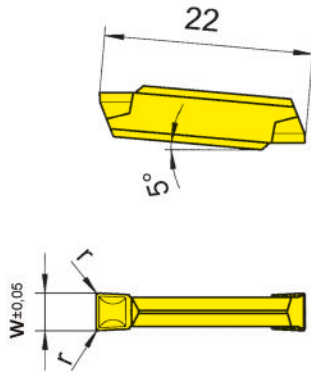
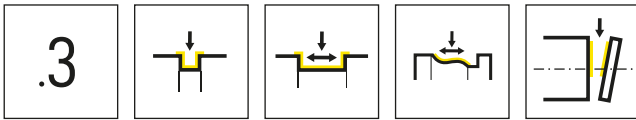
硬质合金牌号

Carbide grades

▲ 库存
on stock

Δ 4周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0200.10	2	0,05	224028	Δ
S224.0250.10	2,5	0,1	224028	Δ
S224.0300.10	3	0,1	224038	Δ
				P ●
				M ●
				K -
				N -
				S O
				H -



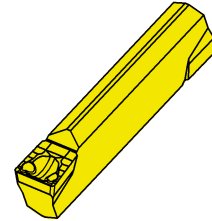
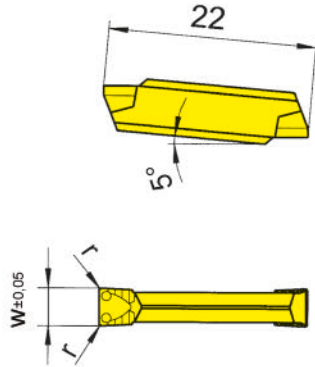
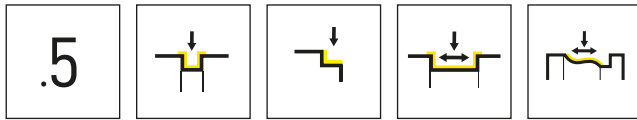
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0300.32	3	0,2	224038	▲
S224.0300.34	3	0,4	224038	▲
S224.0400.32	4	0,2	224048	▲
S224.0400.34	4	0,4	224048	▲
S224.0500.34	5	0,4	224058	▲
S224.0500.38	5	0,8	224058	▲
S224.0600.34	6	0,4	224068	▲
S224.0600.38	6	0,8	224068	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



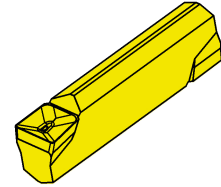
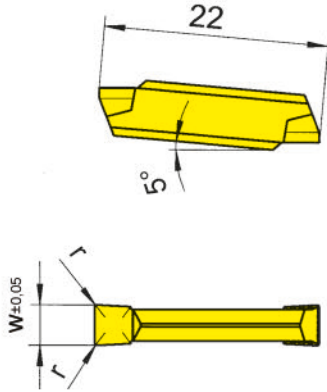
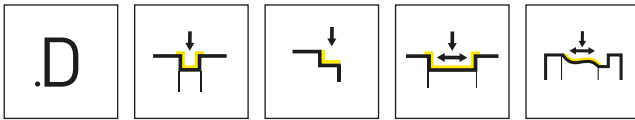
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0200.52	2	0,2	224018	▲
S224.0250.52	2,5	0,2	224028	▲
S224.0300.52	3	0,2	224038	▲
S224.0300.54	3	0,4	224038	▲
S224.0400.52	4	0,2	224048	▲
S224.0400.54	4	0,4	224048	▲
S224.0500.54	5	0,4	224058	▲
S224.0500.58	5	0,8	224058	▲
S224.0600.54	6	0,4	224068	▲
S224.0600.58	6	0,8	224068	▲
				P ●
				M ●
				K -
				N -
				S o
				H -



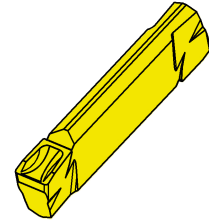
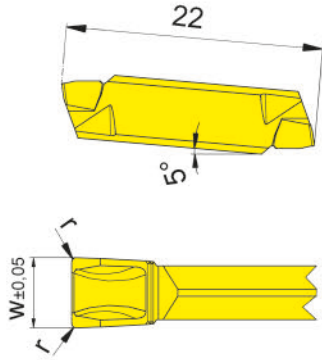
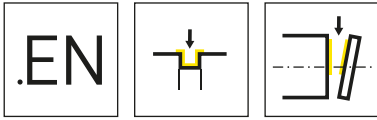
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0200.D2	2	0,2	224018	▲
S224.0200.D2.G	2	0,2	224018	▲
S224.0250.D2	2,5	0,2	224028	▲
S224.0250.D2.G	2,5	0,2	224028	▲
S224.0300.D2	3	0,2	224038	▲
S224.0300.D2.G	3	0,2	224038	▲
S224.0400.D2	4	0,2	224048	▲
S224.0400.D2.G	4	0,2	224048	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



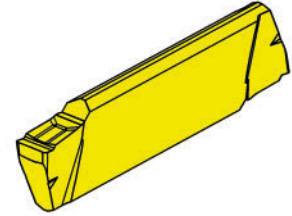
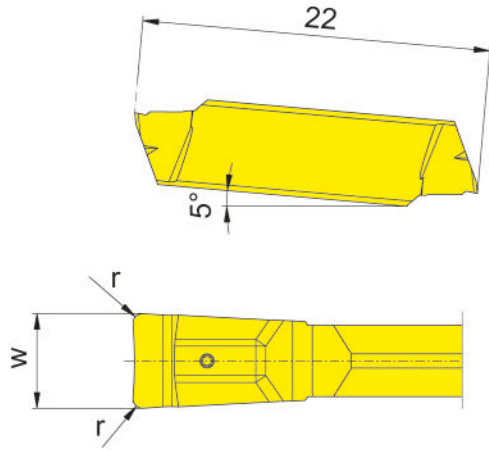
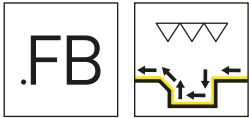
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0300.EN2	3	0,2	224038	▲
				P ●
				M ●
				K -
				N -
				S o
				H -



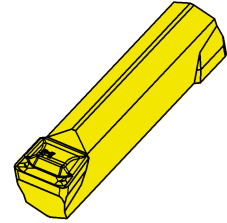
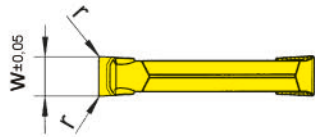
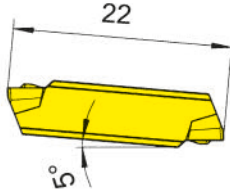
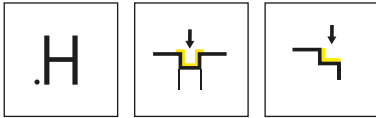
硬质合金牌号

Carbide grades

▲ 库存
on stock

Δ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG6T
S224.FB20.02	2	0,2	224018	Δ
S224.FB30.02	3	0,2	224038	Δ
				P ●
				M ●
				K -
				N -
				S O
				H -



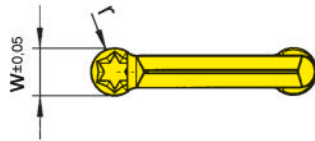
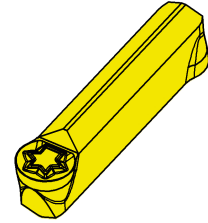
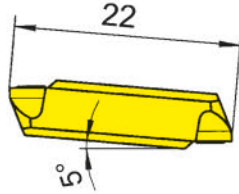
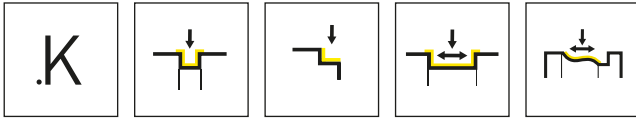
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0300.H4	3	0,4	224038	△
S224.0400.H4	4	0,4	224048	△
S224.0500.H6	5	0,6	224058	△
S224.0500.H8	5	0,8	224058	△
				P ●
				M ●
				K -
				N -
				S O
				H -



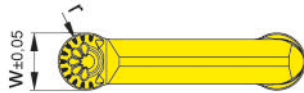
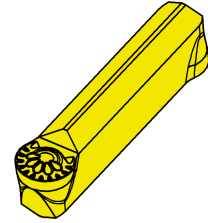
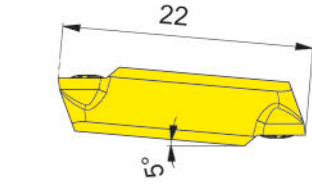
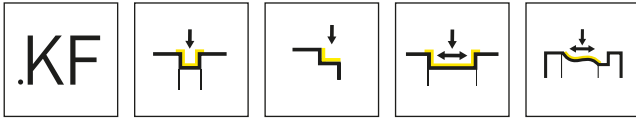
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0010.K2	2	1	224018	▲
S224.0015.K3	3	1,5	224038	▲
S224.0020.K4	4	2	224048	▲
S224.0025.K5	5	2,5	224058	▲
S224.0030.K6	6	3	224068	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



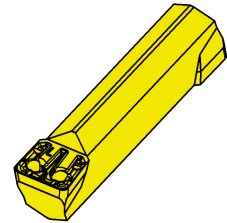
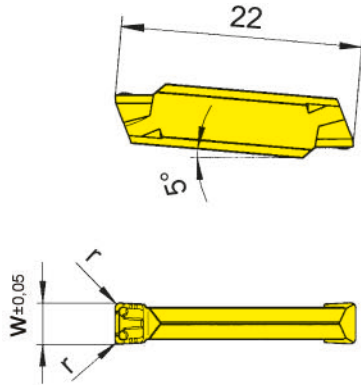
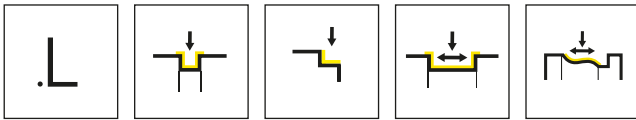
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0015.KF3	3	1,5	224038	▲
S224.0020.KF4	4	2	224048	▲
S224.0025.KF5	5	2,5	224058	▲
S224.0030.KF6	6	3	224068	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



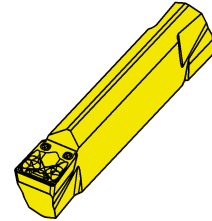
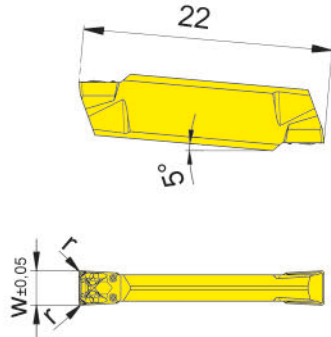
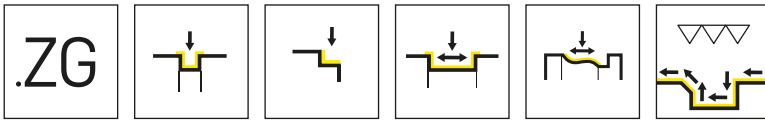
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S224.0300.L4	3	0,4	224038	▲
S224.0400.L4	4	0,4	224048	▲
S224.0500.L4	5	0,4	224058	▲
S224.0500.L6	5	0,6	224058	▲
S224.0600.L4	6	0,4	224068	▲
S224.0600.L6	6	0,6	224068	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



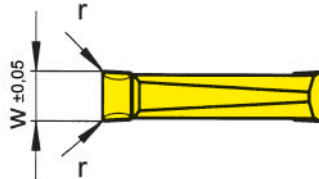
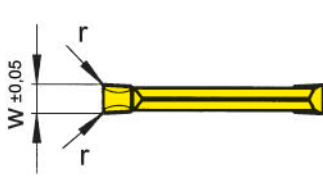
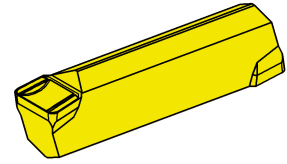
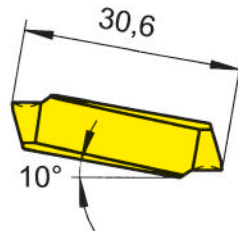
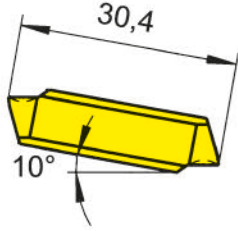
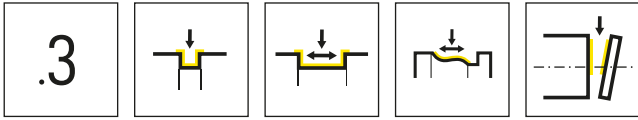
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG6T
S224.0300.ZG2	3	0,2	224038	▲
S224.0400.ZG4	4	0,4	224048	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



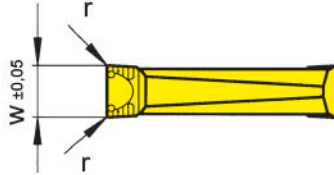
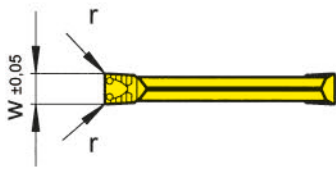
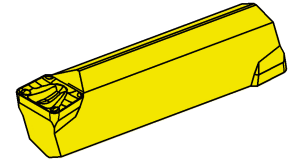
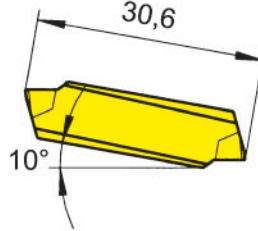
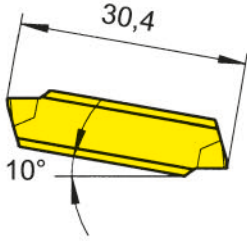
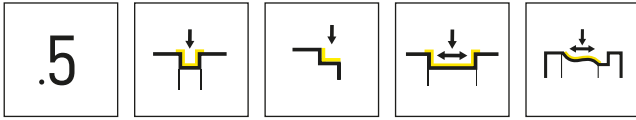
宽度 3 - 5 mm
Width 3 - 5 mm

宽度 6 - 10 mm
Width 6 - 10 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0300.32	3	0,2	229020 • 229030	▲
S229.0300.34	3	0,4	229020 • 229030	▲
S229.0400.32	4	0,2	229030 • 229040	▲
S229.0400.34	4	0,4	229030 • 229040	▲
S229.0500.34	5	0,4	229040	▲
S229.0500.36	5	0,6	229040	▲
S229.0600.34	6	0,4	229051	▲
S229.0600.38	6	0,8	229051	▲
S229.0700.36	7	0,6	229071	▲
S229.0800.36	8	0,6	229071 • 229081	▲
S229.0800.38	8	0,8	229071 • 229081	▲
S229.0800.3K	8	1,2	229071 • 229081	▲
S229.1000.36	10	0,6	229091	▲
				P ●
				M ●
				K -
				N -
				S o
				H -



宽度 3 - 5 mm
Width 3 - 5 mm

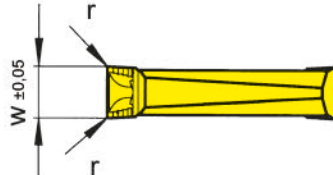
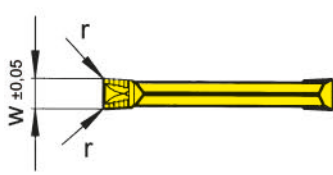
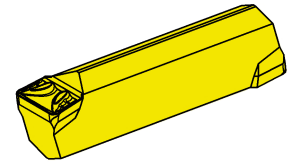
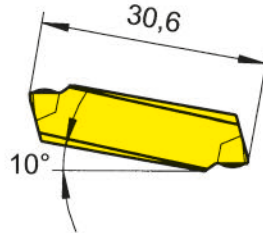
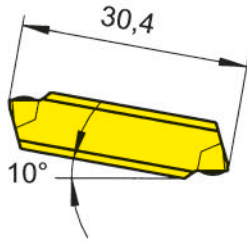
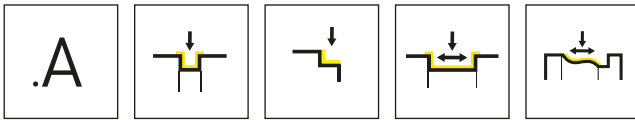
宽度 6 - 8 mm
Width 6 - 8 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0300.52	3	0,2	229020 • 229030	▲
S229.0300.54	3	0,4	229020 • 229030	▲
S229.0400.52	4	0,2	229030 • 229040	▲
S229.0400.54	4	0,4	229030 • 229040	▲
S229.0500.54	5	0,4	229040	▲
S229.0500.56	5	0,6	229040	▲
S229.0600.54	6	0,4	229051	▲
S229.0600.56	6	0,6	229051	▲
S229.0600.58	6	0,8	229051	▲
S229.0800.56	8	0,6	229071 • 229081	△
S229.0800.58	8	0,8	229071 • 229081	△

P	●
M	●
K	-
N	-
S	o
H	-



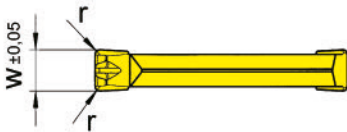
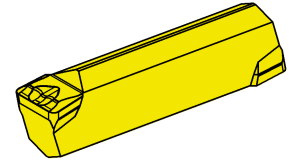
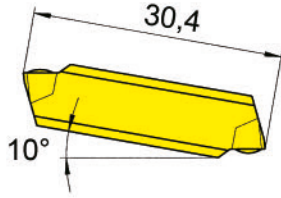
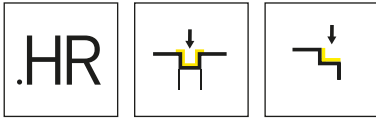
宽度 5 mm
Width 5 mm

宽度 8 - 10 mm
Width 8 - 10 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0500.A4	5	0,4	229040	▲
S229.0500.A6	5	0,6	229040	▲
S229.0800.A6	8	0,6	229071 • 229081	△
S229.0800.A8	8	0,8	229071 • 229081	△
S229.1000.A6	10	0,6	229091	△
				P ●
				M ●
				K -
				N -
				S O
				H -



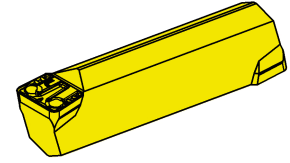
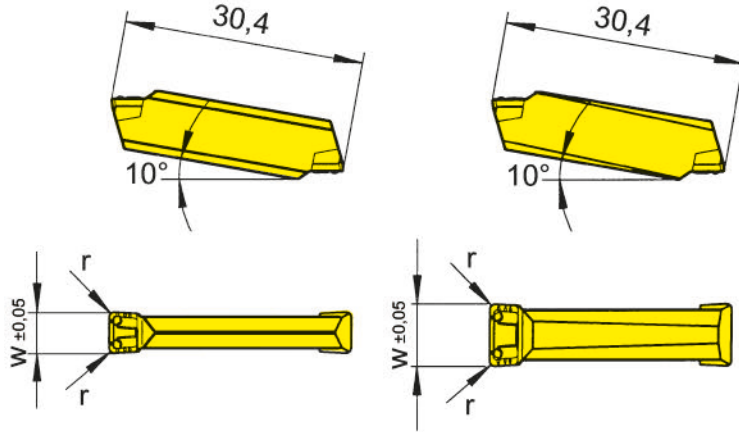
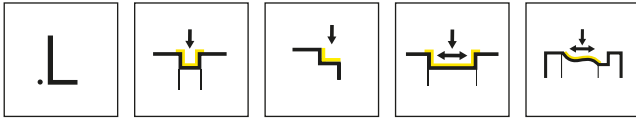
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0300.HR4	3	0,4	229020 • 229030	▲
S229.0400.HR4	4	0,4	229030 • 229040	▲
S229.0500.HR4	5	0,4	229040	▲
S229.0500.HR6	5	0,6	229040	▲
S229.0500.HR8	5	0,8	229040	▲
S229.0600.HR4	6	0,4	229050	▲
S229.0600.HR6	6	0,6	229050	▲
S229.0600.HR8	6	0,8	229050	▲
S229.0800.HR8.PG	8	0,8	229071 • 229081	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 - 8 mm
Width 6 - 8 mm

▲ 库存
on stock

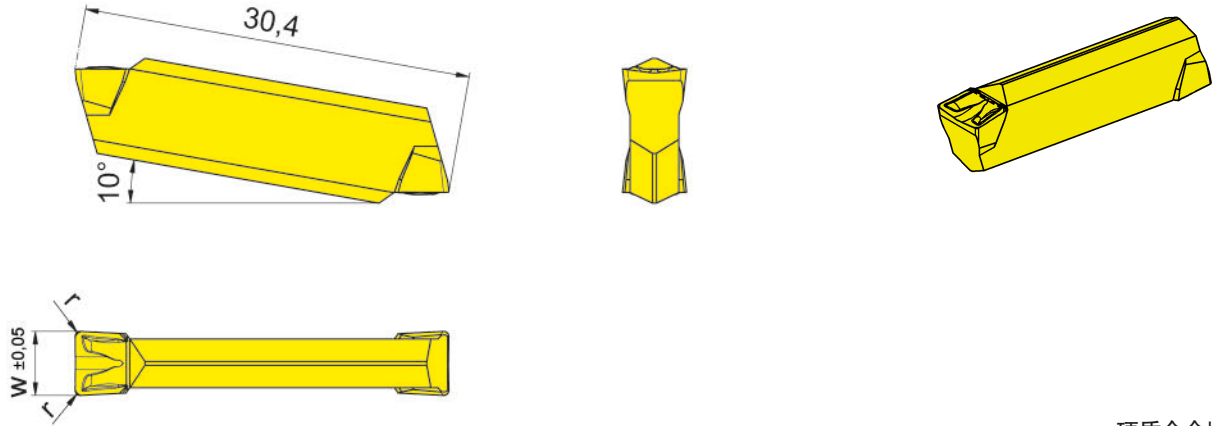
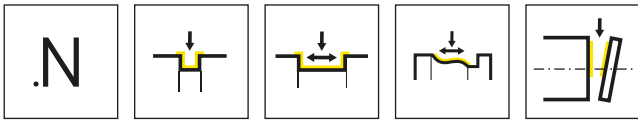
硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0400.L4	4	0,4	229030 • 229040	▲
S229.0400.L6	4	0,6	229030 • 229040	▲
S229.0500.L4	5	0,4	229040	▲
S229.0500.L6	5	0,6	229040	▲
S229.0500.L8	5	0,8	229040	▲
S229.0600.L4	6	0,4	229050	▲
S229.0600.L6	6	0,6	229050	▲
S229.0800.L6	8	0,6	229071 • 229081	▲
S229.0600.L4.PG	6	0,4	229050	▲
S229.0800.L8.PG	8	0,8	229071 • 229081	▲
				P ●
				M ●
				K -
				N -
				S o
				H -

可转位刀片

Indexable insert

S229



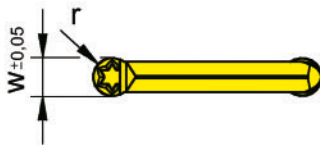
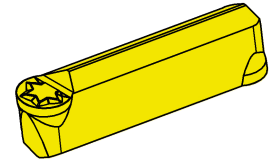
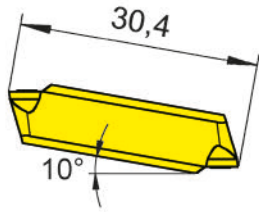
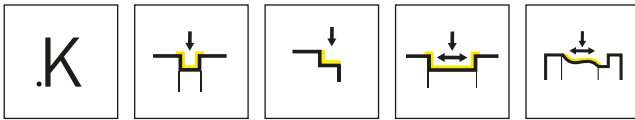
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0300.N2.G	3	0,2	229020 • 229030	▲
S229.0300.N4.G	3	0,4	229020 • 229030	▲
S229.0400.N2.G	4	0,2	229030 • 229040	▲
S229.0400.N4.G	4	0,4	229030 • 229040	▲
S229.0500.N2.G	5	0,2	229040	▲
S229.0500.N4.G	5	0,4	229040	▲
S229.0500.N6.G	5	0,6	229040	▲
S229.0500.N8.G	5	0,8	229040	▲
S229.0600.N4.G	6	0,4	229050	▲
S229.0600.N6.G	6	0,6	229050	▲
				P ●
				M ●
				K -
				N -
				S o
				H -



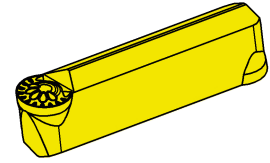
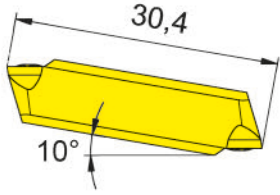
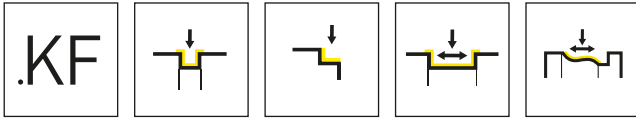
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0015.K3	3	1,5	229020 • 229030	▲
S229.0020.K4	4	2	229030 • 229040	▲
S229.0025.K5	5	2,5	229040	▲
S229.0030.K6	6	3	229050	▲
S229.0040.K8	8	4	229070 • 229080	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



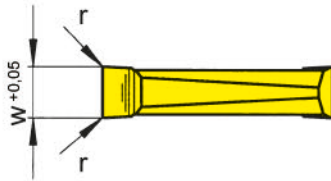
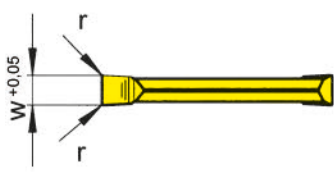
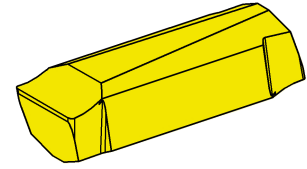
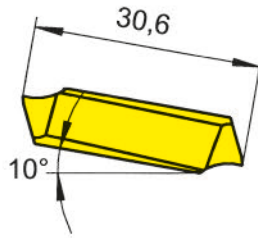
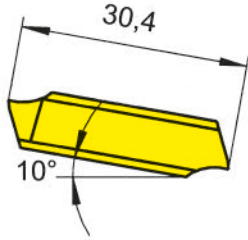
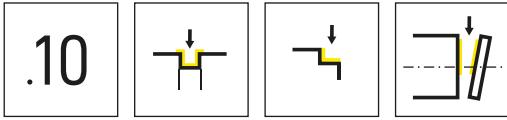
硬质合金牌号

Carbide grades

▲ 库存
on stock

△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
S229.0015.KF3	3	1,5	229020 • 229030	▲
S229.0020.KF4	4	2	229030 • 229040	▲
S229.0025.KF5	5	2,5	229040	▲
S229.0030.KF6	6	3	229050	▲
S229.0040.KF8	8	4	229070 • 229080	▲
				P ●
				M ●
				K -
				N -
				S O
				H -



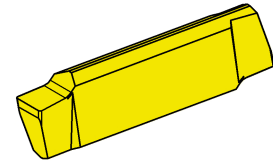
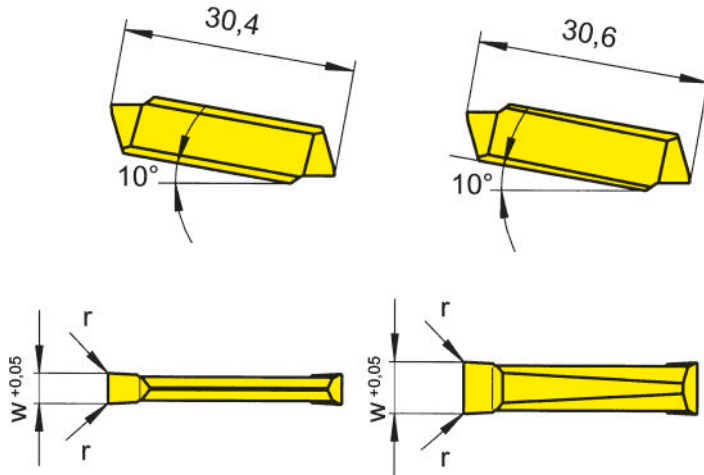
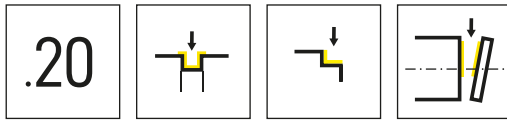
槽宽 2,5 - 5,0 mm
Width of groove 2,5 - 5,0 mm

宽度 5,1 - 10,4 mm
Width 5,1 - 10,4 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
229.0250.10	2,5	0,2	229020	▲
229.0300.10	3	0,2	229020 • 229030	▲
229.0400.10	4	0,2	229030 • 229040	▲
229.0500.10	5	0,2	229040	△
229.0600.10	6	0,4	229051	△
229.0700.10	7	0,4	229071	△
229.0800.10	8	0,4	229071 • 229081	△
229.0900.10	9	0,4	229091	△
229.1000.10	10	0,4	229091	△
				P ●
				M ●
				K -
				N -
				S o
				H -



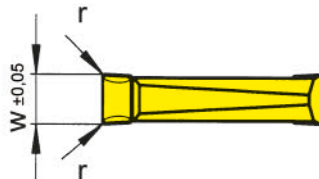
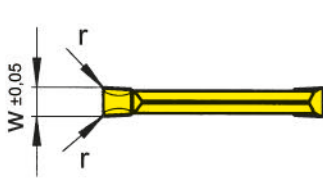
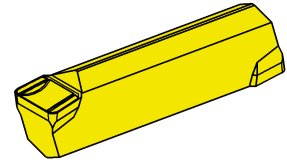
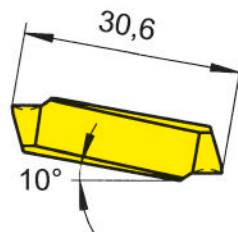
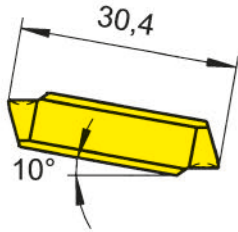
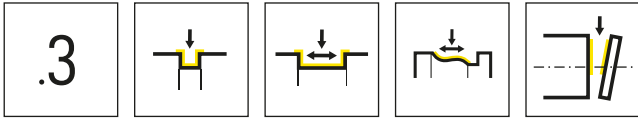
宽度 3 - 5 mm
Width 3 - 5 mm

宽度 5,1 - 10,4 mm
Width 5,1 - 10,4 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
229.0300.20	3	0,2	229020 • 229030	△
229.0400.20	4	0,2	229030 • 229040	△
229.0500.20	5	0,2	229040	△
229.0600.20	6	0,4	229051	△
229.0700.20	7	0,4	229071	△
229.0800.20	8	0,4	229071 • 229081	△
229.0900.20	9	0,4	229091	△
229.1000.20	10	0,4	229091	△
				P ●
				M ●
				K -
				N -
				S O
				H -



宽度 3 - 5 mm
Width 3 - 5 mm

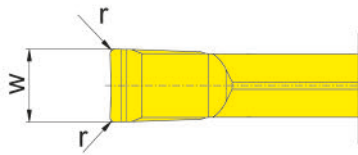
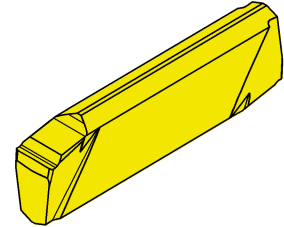
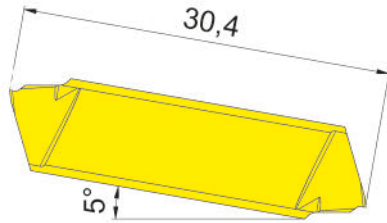
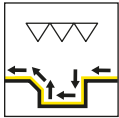
宽度 5,1 - 10,4 mm
Width 5,1 - 10,4 mm

▲ 库存
on stock

硬质合金牌号
Carbide grades
△ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG66
229.0300.31	3	0,2	229020 • 229030	▲
229.0300.34	3	0,4	229020 • 229030	▲
229.0350.31	3,5	0,2	229030	▲
229.0400.31	4	0,2	229030 • 229040	▲
229.0400.34	4	0,4	229030 • 229040	▲
229.0500.31	5	0,2	229040	▲
229.0500.34	5	0,4	229040	△
229.0500.36	5	0,6	229040	△
229.0600.31	6	0,4	229051	△
229.0600.38	6	0,8	229051	△
229.0700.31	7	0,4	229071	△
229.0800.31	8	0,4	229071 • 229081	△
229.0900.31	9	0,4	229091	△
229.1000.31	10	0,4	229091	△

P	●
M	●
K	-
N	-
S	o
H	-



硬质合金牌号

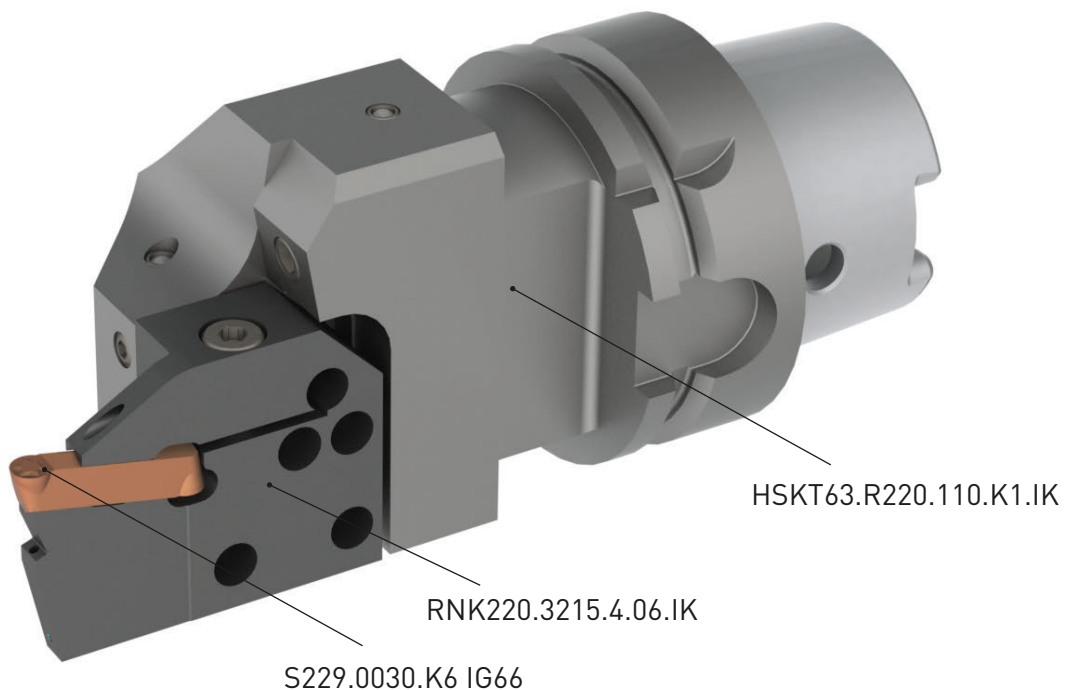
Carbide grades

▲ 库存
on stock

Δ 4 周
4 weeks

产品型号 Part number	w	r	HIS	IG6T
229.FB30.02	3	0,2	229030	Δ
229.FB40.02	4	0,2	229030 • 229040	Δ
				P ●
				M ●
				K -
				N -
				S O
				H -

加工:	摆线车削	Machining:	Trochoidal turning
工件:	轮	Component:	Wheel
材料:	20MnCrS5	Material:	20MnCrS5
刀具:	HSKT63.R220.110.K1.IK RNK229.3215.4.06.IK S229.0030.K6 IG66	Tool:	HSKT63.R220.110.K1.IK RNK229.3215.4.06.IK S229.0030.K6 IG66
	冷却润滑液: 乳化液	Cooling lubricant:	Emulsion
v_c (m/min)	270	v_c (m/min)	270
f (mm/U)	0,9	f (mm/rev)	0.9
a_p (mm)	0,5 - 0,9	a_p (mm)	0.5 - 0.9
刀具寿命:	117 分钟	Tool life:	117 minutes



材料 Material		硬度 Hardness Brinell (HB)	切削速度 v_c (m/min) Cutting speed v_c (m/min)										
			K10	EG35 EG55	HP66	IG36*	IG66	TH35 AS65	DD26	HS36	H20	H54	
P	碳钢 Carbon steel	0,2% C	140		300-180	200-160		340-220	280-180			230-170	200-140
		0,4% C	180		270-150	180-150		320-200	250-140			220-160	180-120
		0,6% C	200		250-120	180-140		300-180	230-120			210-150	160-100
	合金钢 Alloyed steel (<5%)	退火 annealed	180		250-100	180-140		300-180	230-100			210-150	180-120
		淬火 quenched	280		220-90	160-110		280-150	190-90			170-120	160-100
		淬火 quenched	350		200-80	140-90		250-140	170-80			140-80	120-80
	高合金钢 high alloyed steel (>5%)	退火 annealed	200		220-140	120-90		280-200	200-140			120-100	100-90
		硬化 hardened	-										
	铸钢 Cast steel	无合金 unalloyed	180		200-150	200-150		250-200	200-150			180-120	
		合金 alloyed	220		160-100	150-90		220-160	160-100			140-90	
M	不锈钢 Stainless steel	马氏体、铁素体 martensitic, ferritic	200		130-100	180-120	190-140	190 - 140			180-120	190-120	
		奥氏体 austenitic	180			140-110	140-110	140 - 110			140-110	170-120	
K	灰铸铁 Grey cast iron	低抗拉强度 low tensile strength	180	90-60	200-120			250-140	200-120				
		高抗拉强度 high tensile strength	250	90-60	160-120			220-150	160-120				
	球状石墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160		180-130			240-160	180-130				
		珠光体 perlitic	250		160-120			200-160	160-120				
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125		220-120			280-180	220-120				
		珠光体 perlitic	225		190-100			250-160	190-100				
N	铝合金 Al-alloys	不可热处理 not heat treatable	30-80	1000-600						1000-600			
		可热处理 heat treatable	80-120	400-220						400-220			
	铸铝合金 Al-cast-alloy	不可热处理 not heat treatable	80	1000-600						1000-600			
		可热处理 heat treatable	100	600-300						600-300			
	铜合金 Copper-alloys	不可热处理 not heat treatable	90	200-120						210-130			
		可热处理 heat treatable	100	150-90						160-90			
S	耐热合金 Heat resistant alloy (Fe)	退火 annealed	200							50-30			
		硬化 hardened	275							40-20			
	耐热合金 Heat resistant alloy (Ni, Co)	退火 annealed	250							30-20			
		硬化 hardened	350							20-10			

注意 / Note:

* 替代方案: TI25 或 TI26 / * Alternative: TI25 or TI26



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